

Work Order ID 72575

Tuesday, August 02, 2011 1:26:20 PM



Page 1

Item ID:	D2596	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Web, 205 Skidtube					
Start Date:	8/2/2011	Start Qty:	8.00		Cust Item ID:	
Required Date:	8/8/2011	Req'd Qty:	8.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-08-3	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2596	Rev D								

100		0.00							
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	Skidtubes								
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Skidtubes	Memo	0.00							
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Skidtubes	1- Cut D2500-3-100 to length: 99.5"								
	2- Use Jig DT8093 to drill pilot holes #30								
	3- Open to 0.630" diameter as per Dwg D2596								
	4- Deburr								

110	Chemical Conversion Coat per QSI005 4.1	0.00							
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HandFinish	Memo	0.00							
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Hand Finishing									
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120	QC5- Inspect part completeness to step on W/O	0.00							
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QC	Memo	0.00							
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Quality Control									
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(8) 11/08/03

(8) 11/08/03

8 0 11/08/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72575

Tuesday, August 02, 2011 1:26:20 PM



Page 2

Item ID: D2596

Accept



Setup Start



Revision ID:

Stop



Item Name: Web, 205 Skidtube

Start Date: 8/2/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: LG

0.00



Packaging

Memo

0.00

Packaging

(8)

JB 11/08/04

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/04

11-08-11
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 02, 2011 1:26:27 PM

Work Order ID: 72575



Parent Item: D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 8/2/2011

Required Date: 8/8/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: D□99.02.02□Changed QA to QC, Added Step 6 and Cost□DM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured

No

100

Each

115.0000

1

8



Ext'n - I' Beam Web 4"



8

11/08/03

Location

Loc Qty

Loc Code

LG

115

51957

4

66298

111

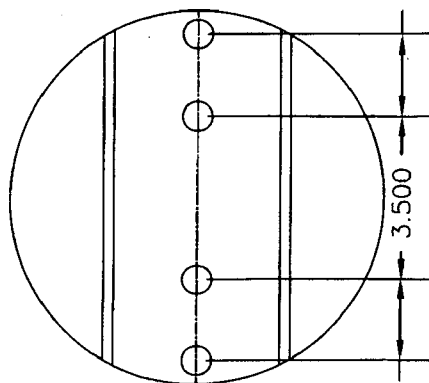
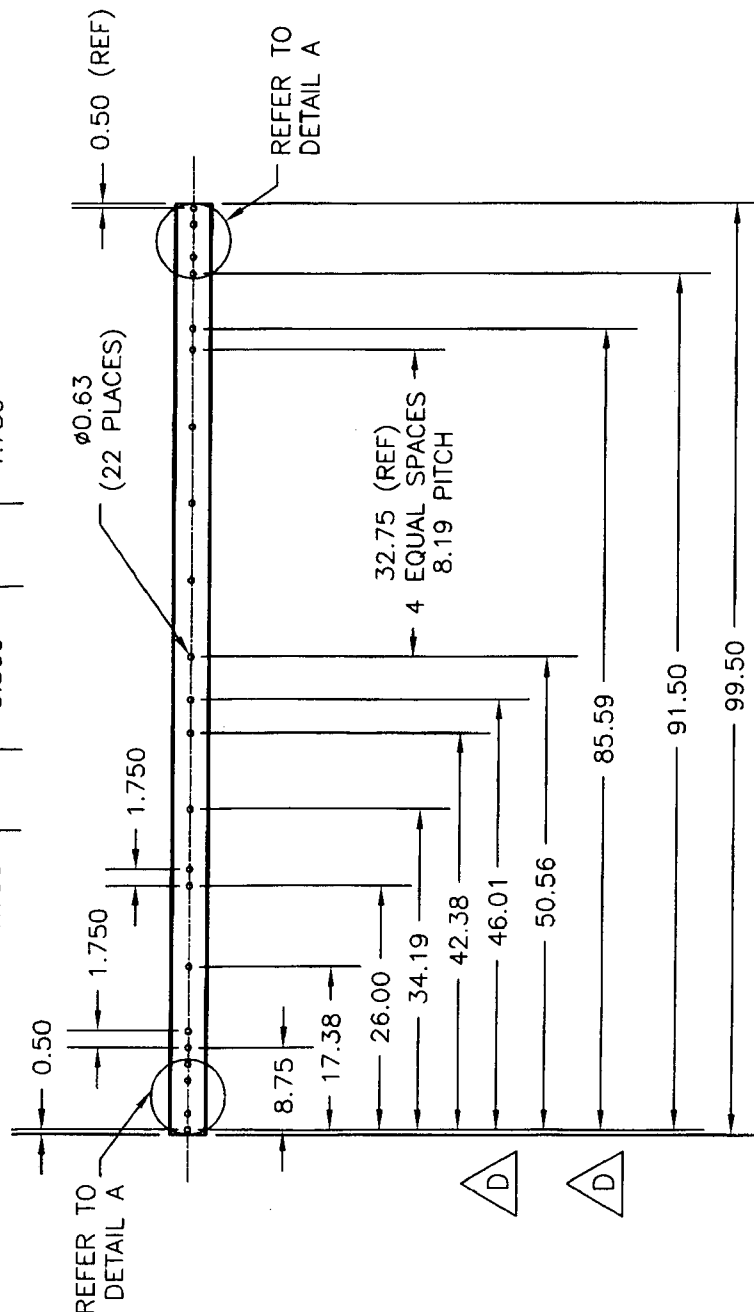
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.06.28SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72573
Pl 11-08-3**DETAIL A**
SCALE 1:4**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

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